

Date: Thursday, 11/16/2006 4:25:26 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP (CASTING DETAIL)	
Job Number	: 29486		Part Number	: D25763	
Estimate Number	: 10510		Drawing Number	: D2576 REV. E1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/16/2006 S.O. No. : N/A		Drawing Revision	: E1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 10/5/2006	
Previous Run	: 23060		Qty:	100 Um: Each	
Written By			g6		
Checked & Approved By					
Comment	: Est: E 02.08.19		Consolidated D2576-1 and D2576-3		KJ/RF

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25761	Step (Casting Detail)
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
		Pick:
	Qty Part# Description	Batch
	1 D2576-1 Step (Casting Detail)	29514
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS1
		1- Machine as per Folio FA332 and Dwg D2576
		2- Deburr
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1
	Identify and Stock	
	Location: LG	RE 06/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2576-3 PAR #: WIA Fault Category: Prod / Machined Parts NCR: Yes No DQA: Yes Date: 06/12/12  
 QA: N/C Closed: Yes Date: 06.12.12

NCR: <u>29486</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/12/08</u>	<u>2</u>	<u>The pocket .063" deep is to thin. 2 parts</u>	<u>B</u> <u>06/12/08</u>	<u>Scrap: destroy. no replace</u>	<u>JF 06/12/08</u>	<u>J</u> <u>06.12.12</u>	<u>B</u> <u>06/12/08</u>	<u>J</u> <u>06.12.11</u>
<u>06/12/09</u>	<u>2</u>	<u>- 1 part came out of jig while machining - 1 part .063 pocket is too deep</u>	<u>B</u> <u>06/12/09</u>	<u>Scrap: destroy no replace.</u>	<u>IL 06/12/09</u>	<u>J</u> <u>06.12.12</u>	<u>B</u> <u>06/12/09</u>	<u>J</u> <u>06.12.11</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 29486

Part Number: D25763

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

18 06/12/12

Job Completion



U De. 12. 01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4,716

DART AEROSPACE LTD	Work Order:	29486
Description: Step	Part Number:	D2576-3
Inspection Dwg: D2576	Rev: E1	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	J.F.	Audited by:	SA	Prototype Approval:	N/A
Date:	06/12/07	Date:	06/12/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF 	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2576	SHEET 1 OF 1
DATE		TITLE	SCALE
99.09.07		STEP	1:1

**RELEASED**  
99.09.08 DS

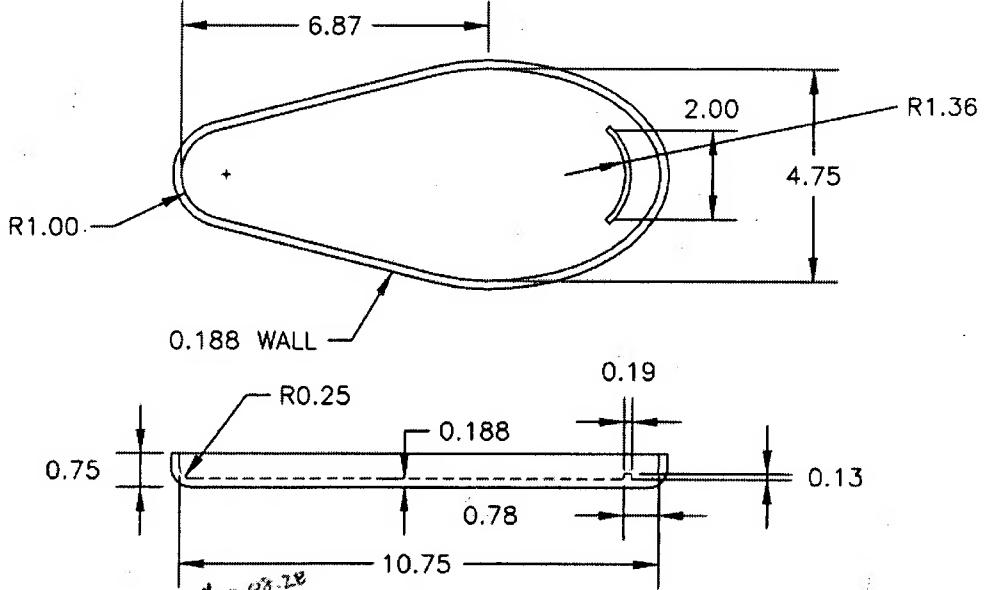
CASTING DETAIL (D2576-1) *(P00.08.28)*

MATERIAL: CAST ALUMINUM ALLOY A-535.2

BREAK SHARP EDGES 0.025 TO 0.050

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES



MACHINING DETAIL (D2576-3) *(P00.08.28)*

**D** 0.250 X 0.65 SLOT  
(4 PLACES)  
IN APPROX. LOCATION SHOWN

0.063 POCKET (LEAVE 0.125)

0.250 X 1.28 SLOT  
**D**  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29486

IT IS ACCEPTABLE TO OPEN  
THIS HOLE 0.125 IN EITHER  
DIRECTION AS SHOWN  
FOR WELDING